

Work Order ID 93161-2

93161

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November-15-12 8:56:55 AM

Item ID: D3912-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Eyebolt Receiver Assembly 6
 Start Date: 11/19/12 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 11/30/12 Req'd Qty: 12.00 *12* Customer:
 Reference:
 Approvals: Process Plan: MLJ Date: 12-11-15 Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Run Start *NR1*
 Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3912 | B | | | | | | | | |
| 100 | Pick Kit | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 110 | | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | 1-Assemble D3912-1/-3/-5 and install rivets as per dwg TRIM RIVETS 1.250" LONG | | | | | | | | |
| | 2- Install helical, spring plunger and spring pin lanyard assy as per dwg | | | | | | | | |
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

55072

13410 6

13-0416

Work Order ID 93161

Tuesday, April 16, 2013 9:17:53 AM

93161

Page 2

Item ID: D3912-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Eyebolt Receiver Assembly
Start Date: 11/19/2012 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 11/30/2012 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------------------|
| 170 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| Packaging | Memo <i>SH072</i> | 0.00 | | | | | | | <i>4/3/11 (6)</i> |
| Packaging | | | | | | | | | |
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | <i>13/4/16</i> |
| Quality Control | | | | | | | | | <i>MF</i> <i>13-4-16</i> |

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data <input type="checkbox"/> | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | |

FAULT CATEGORY

| | | |
|---|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions |
|---|---|---|

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

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Page 1

Work Order ID: 93161
Parent Item: D3912-041
Parent Item Name: Eyebolt Receiver Assembly

Start Date: 11/19/12
Start Qty: 12.00

Required Date: 11/30/12
Required Qty: 12.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B 10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM VERIFIED:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| NAS1149C0663R Washer | | Purchased | No | | | | Each | 128.0000 | | 12 | | 11/13/04/04 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | |
| | | | | ST297 | | 128 | | | | 12 | | | |
| | | | | 116893 | | 128 | | | | | | | |
| D3912-1 Eyebolt | | Manufactured | No | | | 100 | Each | 8.0000 | 1 | 12 | | 11/13/04/04 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | |
| | | | | ST144 | | 8 | | | | | | B92638 (3x) | |
| | | | | 77073 | | 2 | | | | | | B93713 (3x) | |
| | | | | 89084 | | 6 | | | | | | | |
| D3912-3 Eyebolt Block | | Manufactured | No | | | 100 | Each | 25.0000 | 2 | 24 | | 11/13/04/04 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | |
| | | | | ST144 | | 25 | | | | | | B93746 (2x) | |
| | | | | 86594 | | 2 | | | | | | B90533 (6x) | |
| | | | | 88265 | | 7 | | | | | | | |
| | | | | 90533 | | 8 | | | | | | | |
| | | | | 91865 | | 8 | | | | | | | |
| D3912-5 Eyebolt Plate | | Manufactured | No | | | 100 | Each | 40.0000 | 2 | 24 | | 11/13/04/04 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | |
| | | | | ST144 | | 40 | | | | | | B88406 (12x) | |
| | | | | 83367 | | 1 | | | | | | | |
| | | | | 88406 | | 23 | | | | | | | |
| | | | | 89257 | | 16 | | | | | | | |

Picklist Print

November-15-12 8:56:54 AM

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Work Order ID: 93161
Parent Item: D3912-041
Parent Item Name: Eyebolt Receiver Assembly

Start Date: 11/19/12

Required Date: 11/30/12

Start Qty: 12.00

Required Qty: 12.00

D3801-1 Manufactured No
Hand Retractable Spring Plunger

Each 13.0000

12

Location

Loc Qty

Loc Code

ST066

13

75178

11

82615

2

B99271 (1x)

B93789 (2x)

B97963 (3x)

MS20615-4M20 Purchased No
RIVET

100 Each 364.0000

8

96

Location

Loc Qty

Loc Code

GA

364

119546

26

120644

7

121339

9

121463

32

122416

90

122807 -

200

48

MS21209-F615 Purchased No
Heli-Coil

Each 40.0000

12

Location

Loc Qty

Loc Code

ST304

40

121561

40

M125097

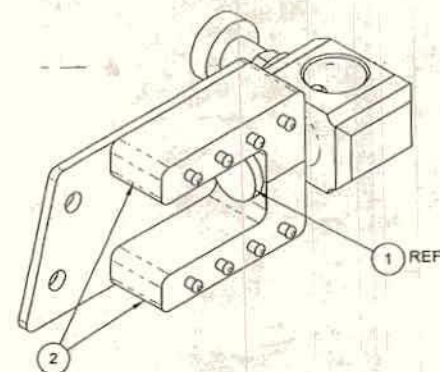
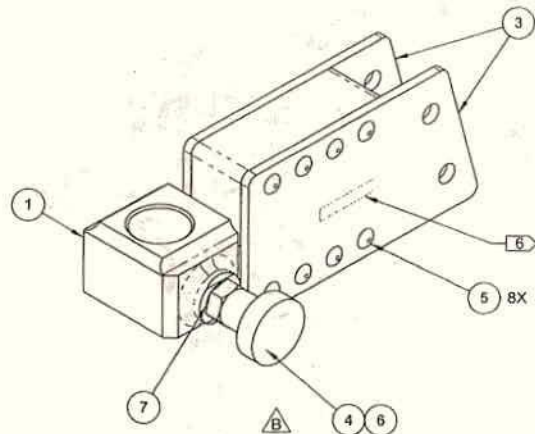
(6x)

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Shop Packet Print

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| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|---------------|-----------------------|
| | X | D3912-041 | EYEBOLT RECEIVER ASSY |
| 1 | 1 | D3912-1 | EYEBOLT |
| 2 | 2 | D3912-3 | EYEBOLT BLOCK |
| 3 | 2 | D3912-5 | EYEBOLT PLATE |
| 4 | 1 | D3801-1 | SPRING PLUNGER |
| 5 | 8 | MS20615-4M20 | RIVET |
| 6 | 1 | MS21209-F615 | HELICAL |
| 7 | 1 | NAS1149F0332P | WASHER |



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

93161 MCG
12-11-15

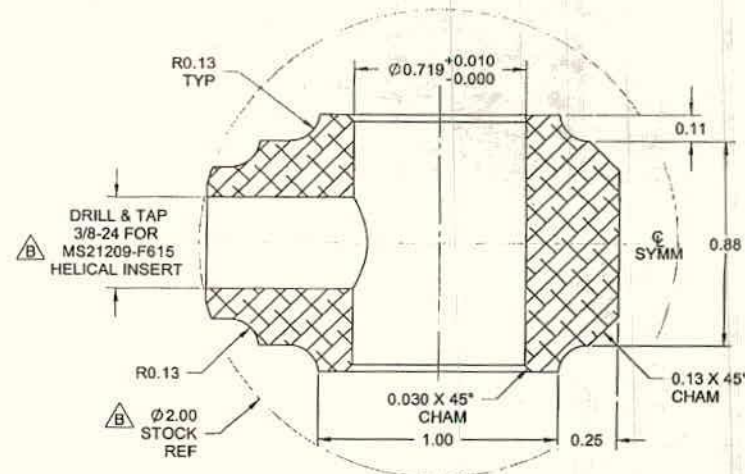
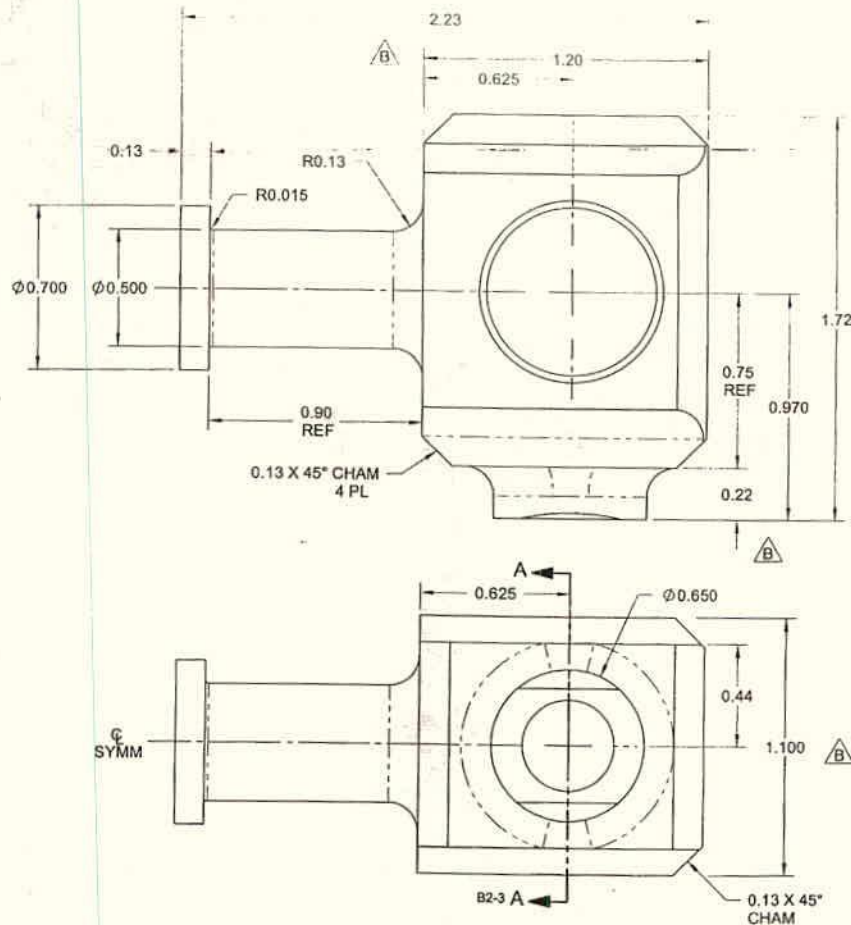
RELEASED
2010-07-16

| B | D3801-1 WAS D3810-1 SPRING PLUNGER; D4023-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1. | JPH | 10.06.28 |
|------------|--|-----|----------|
| A | NEW ISSUE | JPH | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | ALS | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.06.28 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B
SHEET 1 OF 3
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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D3912-1 EYEBOLT

NOTES:

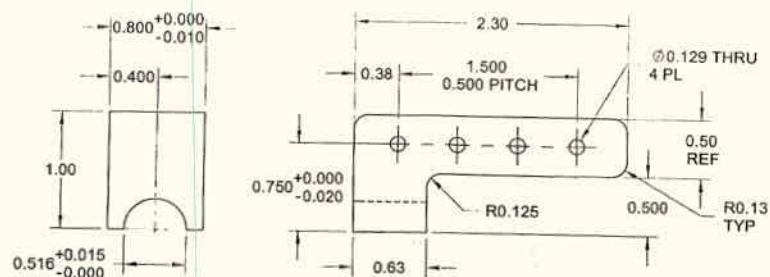
- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs

| | | | |
|------------|----------|------------------------------|--------------|
| DESIGN | AL5 | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3912 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | EYEBOLT RECEIVER ASSY | |
| DATE | 10.06.28 | NTS | |

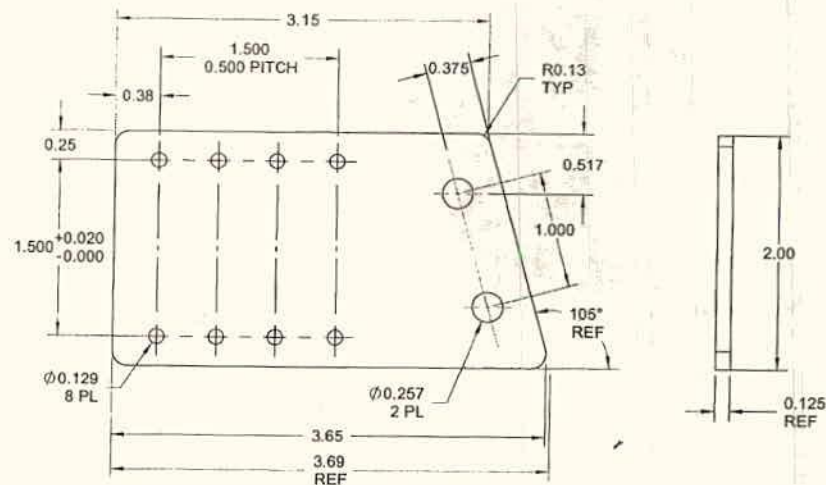
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RELEASED
2010-07-16

93161



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16

| | | | |
|--|----------|--|--------------|
| DESIGN | AKS | DART AEROSPACE LTD | |
| DRAWN | AKS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AKS | DRAWING NO. | REV. B |
| MFG. APPR. | AKS | D3912 | SHEET 3 OF 3 |
| APPROVED | AKS | TITLE | SCALE |
| DE APPR. | AKS | EYEBOLT RECEIVER ASSY | NTS |
| DATE | 10.06.28 | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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